

shp Oct-14

Work Order ID 73024

Wednesday, August 24, 2011 8:59:04 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 8/24/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5

W

11

10

13

AG Cor MLT 11-10-11 (S)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

14514
117884

R11.10.04

5

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 0 BR 11/10/04

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/10/04

(X5
RH)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5 RH BR 11-9-4.

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

11-10-06

5

0

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

5

0

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11-10-06

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



8 u/10/06

8 u/10/06

XS

R4

5-BR 11-10-6

Dart Aerospace Ltd

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

5X of M-1 11/10/07

230

Wing Walk as per dwg QSI005 4.4 Batch 118313

0.00



HandFinish

Hand Finishing

Memo

0.00

5 of 11-10-11

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

5 of 11-10-11

Dart Aerospace Ltd

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/10/11 SP (5)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11 10 13 (5)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: B

SP 11-10-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11 [Signature]

ME
11-10-11

Dart Aerospace Ltd

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Picklist Print

Wednesday, August 24, 2011 8:59:01 AM

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011


Required Date: 10/14/2011

Start Qty: 5.00


Required Qty: 5.00

Comments: IPP Rev:A 104.03.22 ☐ New issue ☐ KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 		Manufactured	No			110	Each	10.0000	1	5			
Step													

Location	Loc Qty	Loc Code
WA <u>373029</u>	10	
71963	10	

D3067-1 		Manufactured	No			110	Each	54.0000	1	5			
End Plate													

Location	Loc Qty	Loc Code
WA <u>373404</u>	53	
67582	2	
70700	51	
WA016	1	
68214	1	

D3219-1 		Manufactured	No			110	Each	88.0000	2	10			
Plate													

Location	Loc Qty	Loc Code
WA <u>373410</u>	48	
72128	48	
WA017	40	
68338	40	

Dart Aerospace Ltd

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Page 2

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No 180 Each 87.0000 2 10
Spacer



11.10.06

MS20600-AD4W4 Purchased No 180 Each 1,520.000 16 80
Rivets



11.10.06

Location Loc Qty Loc Code

WA 87
70699 87

Location Loc Qty Loc Code

ST321 1515
116188 59
117364 1000
117601 200
117885 195
118267 61
WA018 5
116712 5

D3065-041 Manufactured No 180 Each 0.0000 1 5



Step Leg Assembly Hi

D3067-1 Manufactured No 180 Each 54.0000 1 5



End Plate



11.10.06



11.10.06

Location Loc Qty Loc Code

WA 53
67582 2
70700 51
WA016 1
68214 1

5

Wednesday, August 24, 2011 8:59:01 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

250

Each

157.0000

2 10

Bolt

Location

Loc Qty

Loc Code

ST353

157

117619

3

117794

14

118112

40

118451

50

118628

50

D3235-1

Manufactured

No

250

Each

177.0000

2 10

Mounting Lug

Location

Loc Qty

Loc Code

ST471

77

69837

77

ST481

100

71965

100

D3278-041

Manufactured

No

250

Each

26.0000

1 10 5

Support Assembly

Location

Loc Qty

Loc Code

ST471

26

69741

26

250

Each

0.0000

16 80

AN960JD4T6

NAS1149D0463J

Purchased

No

Washer

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

4 20

Washer

Wednesday, August 24, 2011 8:59:02 AM

Shop Packet Print

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

No

250

Each

157.0000

2 10

Bolt

Location

Loc Qty

Loc Code

ST341

157

117794

7

118012

50

118451

100

Manufactured

No

250

Each

132.0000

2 10

D26T8

Bushing

Location

Loc Qty

Loc Code

ST019

132

70702

28

71600

104

Manufactured

No

250

Each

304.0000

4 20

D2230-3

Lug

Location

Loc Qty

Loc Code

ST

220

70694

20

71964

100

72125

100

ST476

4

53881

4

ST480

80

70973

80

Dart Aerospace Ltd

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Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

254.7845 1.2 6



Abraison Strip

Location

Loc Qty

Loc Code

ST403

38.1149

68076

38.1149

ST409

216.6696

63735

0.6696

71164

216

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

1,835.000



Nut

Location

Loc Qty

Loc Code

ST300

1835

117441

190

117601

400

117885

245

118451

1000

AN4-13A

Purchased No

250 Each

1,006.000



Bolt

Location

Loc Qty

Loc Code

ST357

1006

117962

4

118078

594

118350

108

118351

300

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Start Qty: 5.00

Required Qty: 5.00

MS21042L5



Purchased

No

250

Each

1,153.000



2

10

Nut

Location

Loc Qty

Loc Code

ST300

1153

116105

5

116548

53

117441

494

117591

15

117611

90

118179

496

MS21042L4



Purchased

No

250

Each

4,539.000



8

40

Nut

Location

Loc Qty

Loc Code

ST300

4539

117441

394

117601

645

117885

1500

118451

2000

AN960JD10



NAS1149D0363J

Purchased

No

250

Each

0.0000



4

20

Washer

Wednesday, August 24, 2011 8:59:02 AM

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DART

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07 06 04 -ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

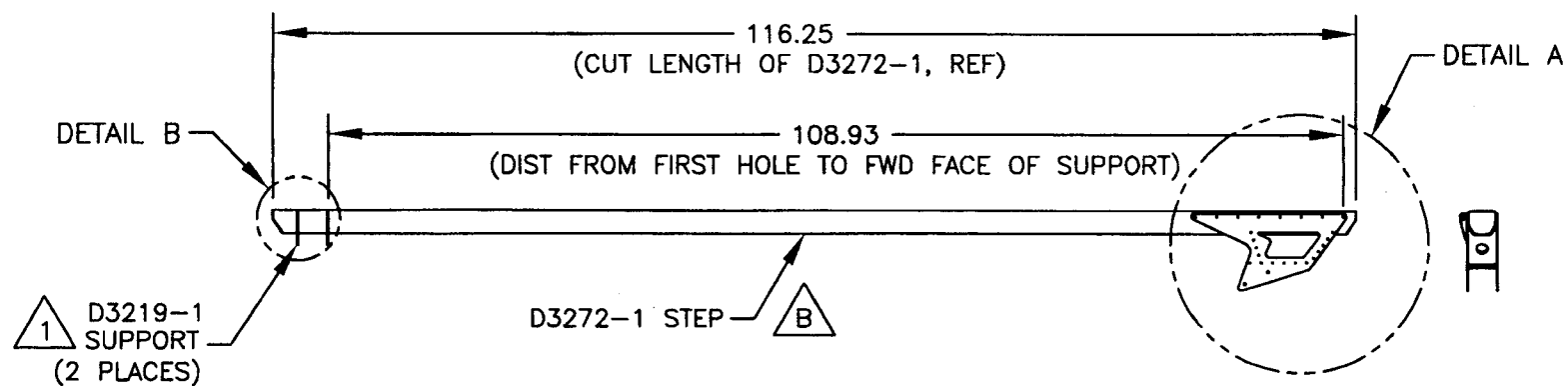
GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005/4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

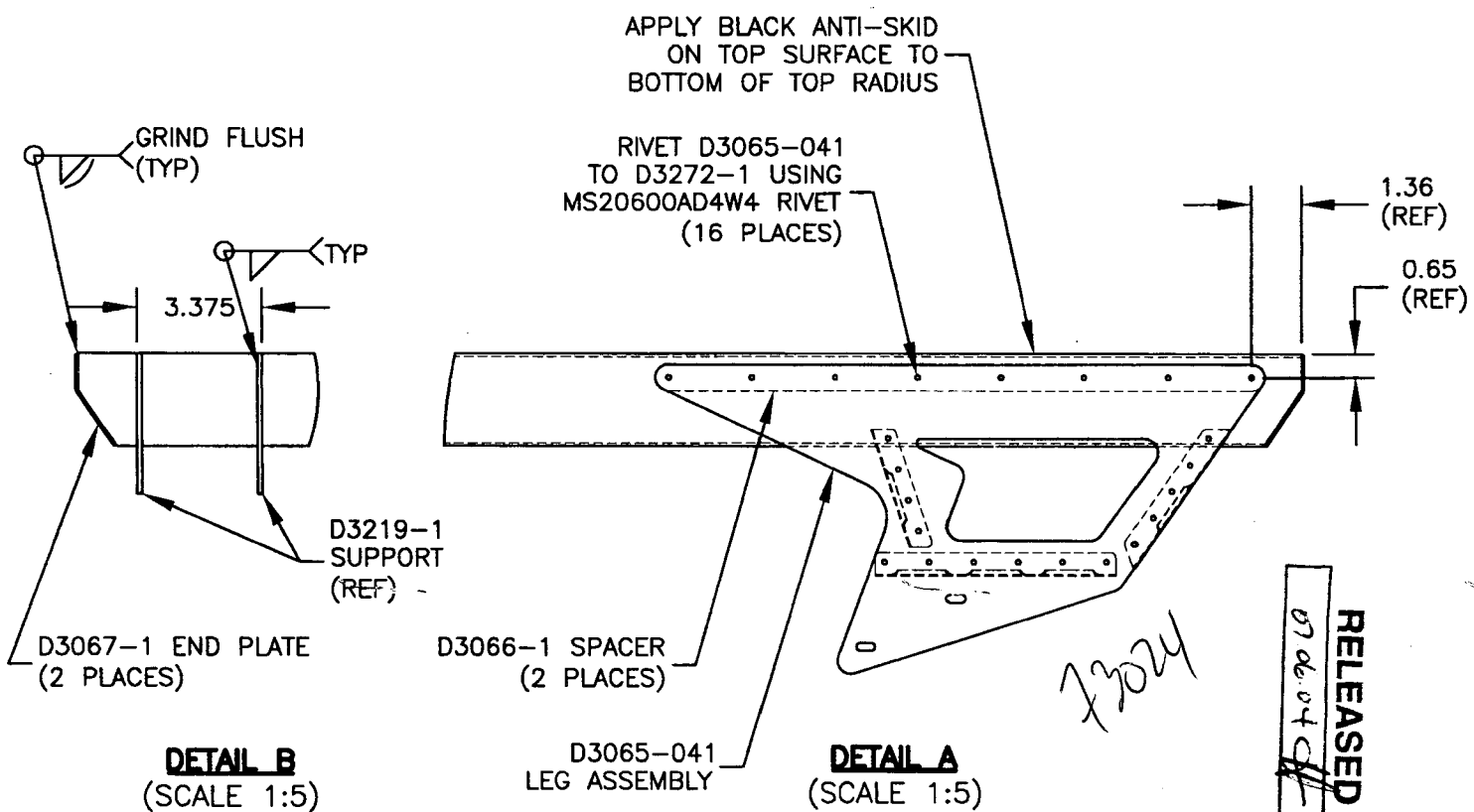
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



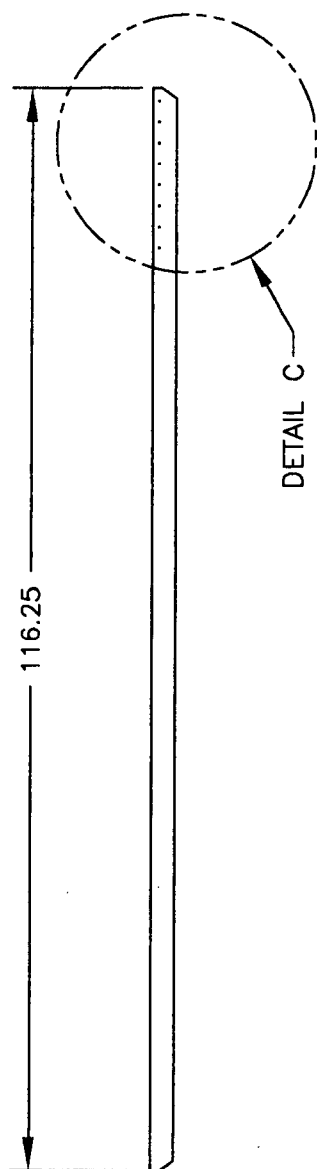
DESIGN	q	DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED		REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
		STEP ASSEMBLY, LH LONG		SCALE 1:20

RELEASED
07.06.04

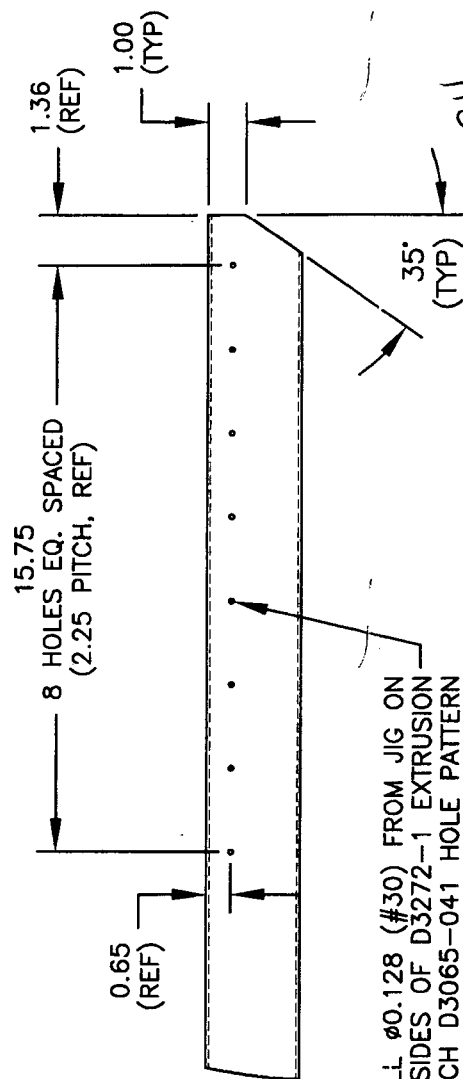
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DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



△ D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty, -312	Part Number	Description
X							X	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G

Date: 08.10.06